

Work Order ID 113801

February-24-14 11:15:34 AM

113801

Page 1

Item ID: D2665-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, RH, Fwd,Aft, Out
Start Date: 2/24/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 2/24/14 Req'd Qty: 4.00 ***4*** Customer:
Reference:
Approvals: Process Plan: MLJ Date: 4-02-20 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2665	Rev D
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100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Program batch number2- Machine Step # 1 of Folio and visually inspect as
per attached Dimension Sheet 3- Machine Step # 2 of Folio and visually
inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and
visually inspect as per attached

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O found in
FAI - no parts found
close for

114-03-05

114-03-05

114-03-05

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00		14-3-7		4			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00				4		14-3-11	
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 11:21 OVEN TEMPERATURE: 320 FINISH TIME: 10:40	0.00				4	φ		mm 14/03/16

February-24-14 11:15:34 AM

Page 3

h 150227

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. <u>14-3657</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td><i>manufatures</i> ☐</td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐	<i>manufatures</i> ☐
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒															
Large Fab ☐	Composite ☐	Supplier ☐	<i>manufatures</i> ☐															

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Found that powder coat build up around Pilgered holes and powder coat is thin in some areas. Re employee was not correctly trained on how to correctly powder coat		Strip entire Sashly Qty x4			
Doc/Data						Re Alodine if necessary as per Q52005			
Equip/Tooling						Re powder coat as per Q52005			
Handling/Pre						Start Fin temp temp			
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-24-14 10:03:59 AM

Work Order ID: 113801

113801

Parent Item: D2665-2

D2665-2

Parent Item Name: Saddle, RH, Fwd,Aft, Out

Start Date: 2/24/14

Required Date: 2/24/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C 00.11.01 Removed P/O for Powder Coat - in house process
EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003		Manufactured	No			100	Each	31.0000	1	4			
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D6101-003

Saddle Billet, 7075

**

SL 14-3-2

Location

Loc Qty

Loc Code

MAT045

31

108298

12

109528

7

111016

8

112456

4

109528

1

113327

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	113801
Description: 206 Saddle, Outboard, Right side		Part Number:	D2665-2
Inspection Dwg: D2665 Rev: D DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

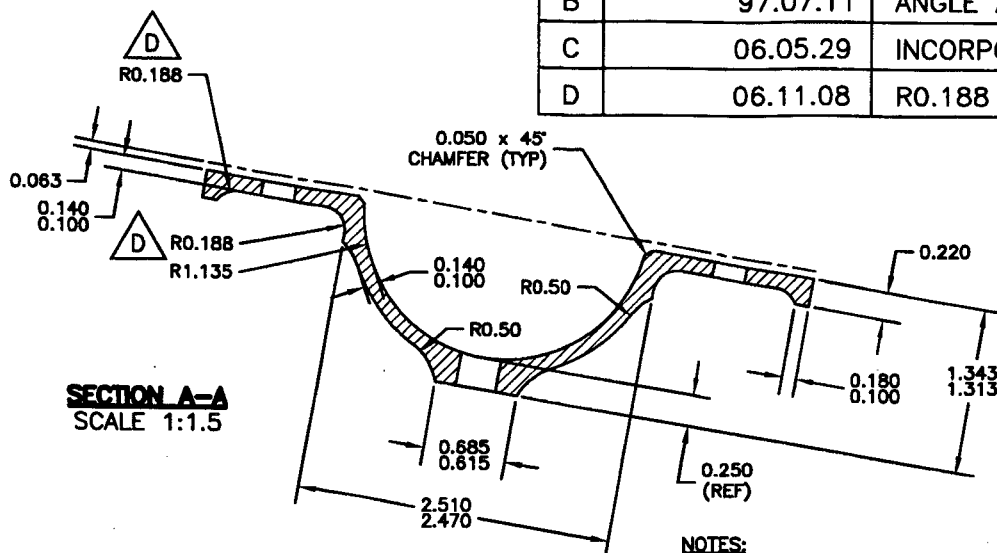
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.118	.118	.119	
B	0.100	0.140		.115	.114	.116	.119	
C	1.125	1.145		1.137	1.135	1.1378	1.136	
D	0.615	0.685		.670	.670	.670	.670	
E	0.240	0.260		.248	.249	.249	.250	
F	1.313	1.343		1.325	1.322	1.325	1.325	
G	0.210	0.230		.223	.220	.220	.222	
H	0.100	0.180		.130	.130	.130	.130	
I	2.470	2.510		2.495	2.495	2.495	2.495	
J	1.565	1.585		1.574	1.5725	1.5743	1.573	
K	0.235	0.240		.238	.238	.238	.238	
L	0.100	0.120		.113	.113	.112	.113	
M	0.990	1.010		.998	.998	.998	.998	
N	0.510	0.515		.513	.513	.513	.513	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.248	1.248	1.248	1.248	
Q	2.495	2.505		2.498	2.498	2.498	2.498	
R	0.312	0.318		.314	.314	.314	.314	
S	0.315	0.322		.316	.316	.316	.316	
T	2.495	2.505		2.499	2.500	2.500	2.500	
U	1.357	1.367		1.360	1.360	1.360	1.360	
V	0.787	0.807		.792	.791	.791	.792	
W	0.540	0.560		.546	.547	.547	.549	
X	1.674	1.684		1.677	1.677	1.677	1.677	
Y	0.256	0.262		.258	.258	.258	.258	
Z	0.912	0.932		.921	.922	.922	.923	
AA	0.490	0.510		.499	.500	.498	.497	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								
Accept/Reject								

Measured by: <i>SL</i>	Date: 14-03-05
Audited by: <i>SL</i> 14-3-7	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	<i>SL</i>



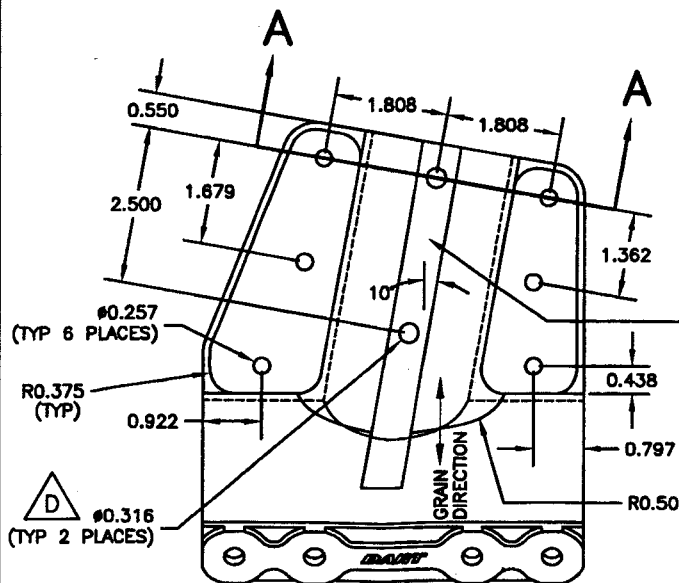
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



RELEASED
07.02.12

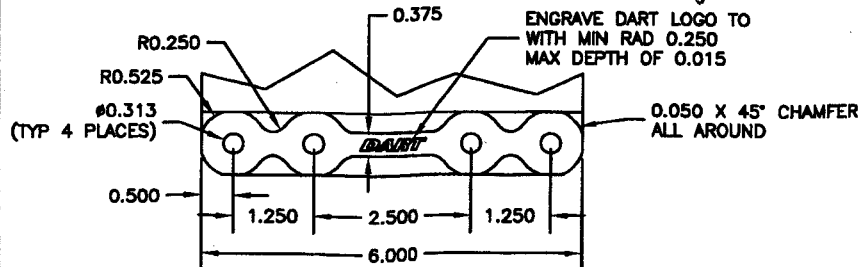
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D8101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

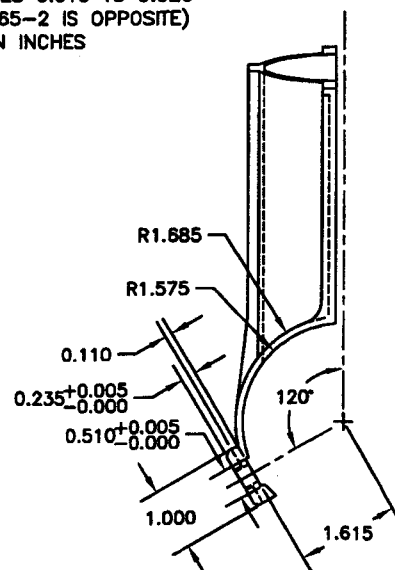


ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

113801
MCS
1402-26



ENGRAVE DART LOGO TO
WITH MIN RAD 0.250
MAX DEPTH OF 0.015



D2665-1 SADDLE FWD OUTSIDE HIGH

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